

Work Order ID 66936-2

Thursday, March 03, 2011 8:41:53 AM

Page 1

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 3/3/2011

Start Qty: 160.00

Required Date: 3/11/2011

Req'd Qty: 160.00

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut @ meter

0.00

CZ 11/03/04

110



HAAS

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2-deburr

use P10 to meter P10 13611

CZ 11/03/04 (160)

Purchasing

Machine as per drawing D2230 REV.G

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Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/3/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

re'd + inspect fasteners damage
attached CQC to w/o

4/3/3/55

130



QC

Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8 u/03/31

counts
255

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

X55 0 22 u/03/04

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Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/3/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 160.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

55 BR 11-4-4

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 9:05

OVEN TEMPERATURE: 320

FINISH TIME: 9:35

55 BR 11-4-4

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

55 AL 11/04/06

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Page 4

Item ID: D2230-3

Revision ID:



Item Name: Lug

Start Date: 3/3/2011 Start Qty: 160.00

Required Date: 3/11/2011 Req'd Qty: 160.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging	Identify as per dwg & Stock Location: <u>476</u> Memo	0.00 0.00							<u>4/14/05</u> (55)
200  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/4/05</u> <u>MF</u> 11-04-05

Picklist Print

Thursday, March 03, 2011 8:42:04 AM

Page 1

Work Order ID: 66936

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 3/3/2011

Start Qty: 160.00

Required Date: 3/11/2011

Required Qty: 160.00

Comments:

IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder
coat ☐ EC
25 JLM VERIFIED BY:EC
☐

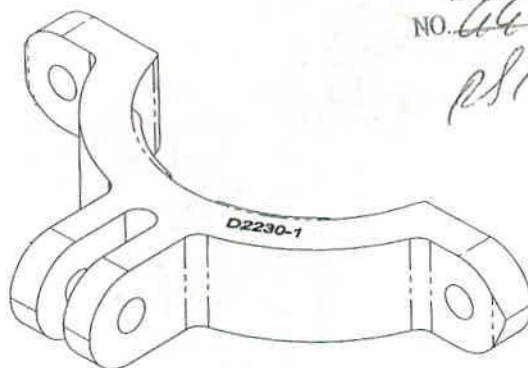
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	f	485.9514	0.0683	11.50316		C2 11/03/04	
Lug Extrusion													
					<u>Location</u>			<u>Loc Qty</u>					
					MAT06			485.9514265					
					43722			180					
					45800			17.9514265					
					63005			288					

D2230-3P

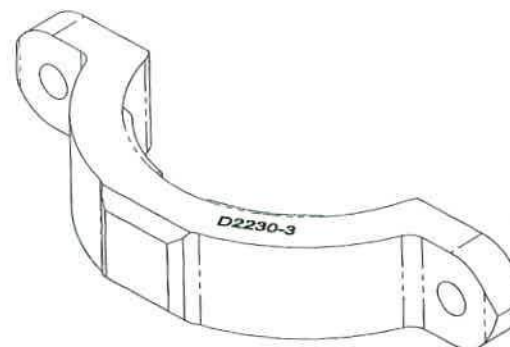
Qty 160

3/3/21 160

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44936
PS11-033



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
01/01/16





NOTES:

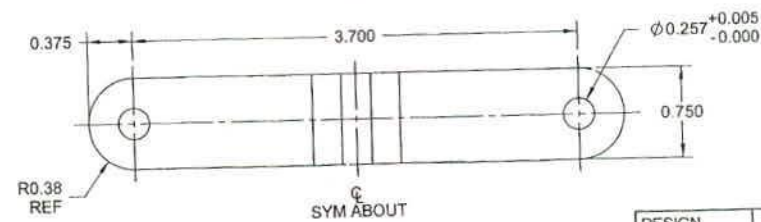
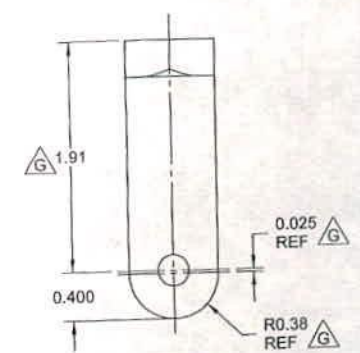
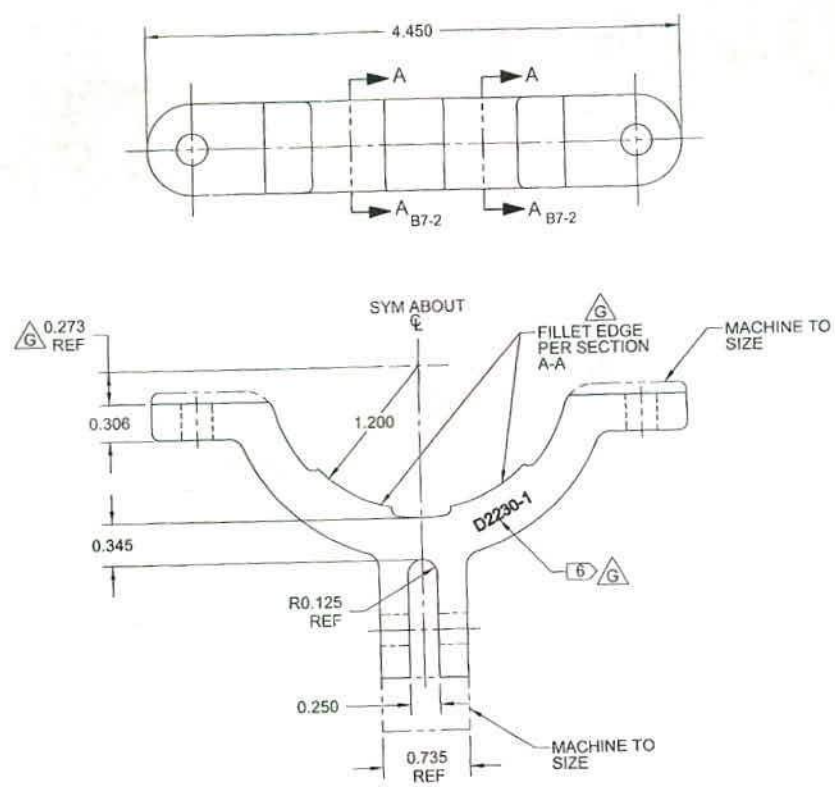
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

u/o 46934

 R0.06 MIN - R0.10 MAX
2 PL

 **SECTION A-A** D4-2
SCALE 2X



D2230-1 MOUNTING LUG

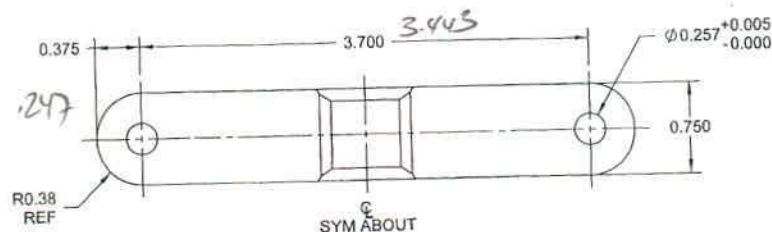
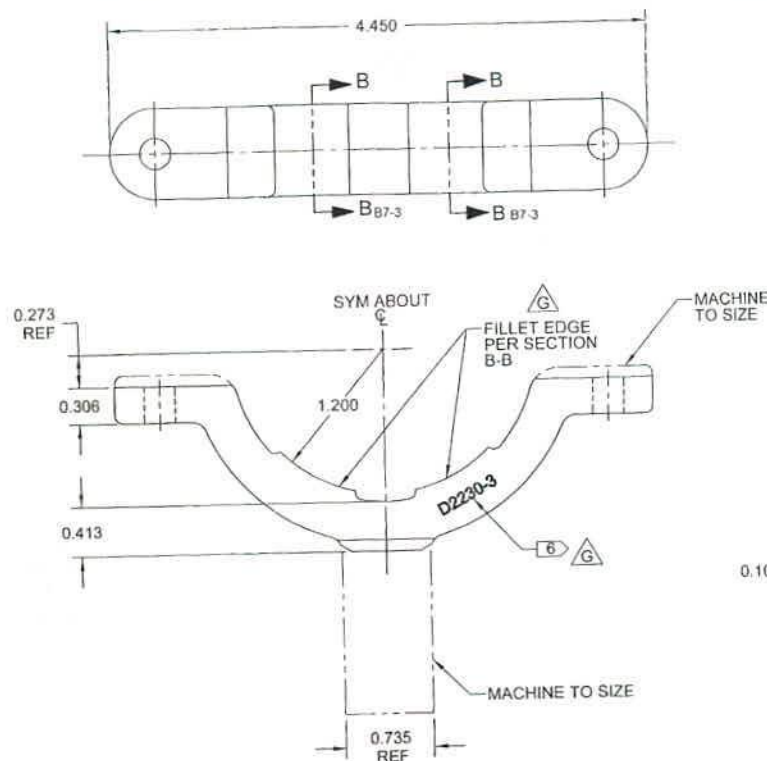
RELEASED
07/06/25

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2230	REV. G SHEET 2 OF 3
MFG. APPR.		TITLE MOUNTING LUG	SCALE NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	
DATE	09.01.16		

SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17855
Date: Mar 31, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13611	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART: D2423 B	Each	160	55	
D3235-1 Mounting Lug Material supplied by DART: D2423 B	Each	60		
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

55

D2230-3

Mounting Lug

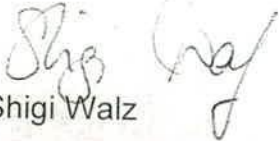
13611

MATERIAL: supplied by DART D2423 B63005

84103/31

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, March 31, 2011